

Work Order ID 129330

Tuesday, February 03, 2015 1:34:49 PM

129330

Ship Feb 2015

Page 1

Item ID: D350-567-115B

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Interior Floor Window, Blank

Stop ***NS2***

Start Date: 2/3/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: UMF Date: 15-2-3 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9637	A

label 5d

MJ 1508-05

100 Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-567-115b CHG001

(10)

DAS
46
9-89

FEB 10 2015

110 Pick Kit
Packaging

0.00

110

Packaging

Memo

0.00

Packaging

DAS
06
9-89

FEB 05 2015

DAS
28
9-89

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

(1x)

DAS
46
9-89

FEB 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129330

Tuesday, February 03, 2015 1:34:49 PM

129330

Page 2

Item ID: D350-567-115B

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Interior Floor Window, Blank

Start Date: 2/3/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					(1x)	DAS 46	FEB 10 2015	
Packaging	Memo	0.00					9-89		
Packaging	Identify and pack for shipping as per PPP D350-567-115b								
	Location: _____								
	PPP Rev: _____								
		4 Sold							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS 15-02-10

(H) 15-2-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 129330

129330

Parent Item: D350-567-115B

D350-567-115R

Parent Item Name: Interior Floor Window, Blank

Start Date: 2/3/2015

Required Date: 2/10/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3293-1B		Manufactured	No			110	Each	1.0000	1	1			

D3293-1R

Doubler, Blank

DAS
46
9-89

Location

Loc Qty

Loc Code

Mezz

1

93448

1

**

MF 15-2-3

DAS
86
9-89

DAS
28
9-89

D3294-1B

Manufactured No

D3294-1R

Bracket, Blank

DAS
46
9-89

Location

Loc Qty

Loc Code

Mezz

1

93450

1

**

MF 15-2-3

DAS
86
9-89

DAS
28
9-89

D3295-041B

Manufactured No

D3295-041R

Floor Window, Blank

DAS
46
9-89

Location

Loc Qty

Loc Code

ST409

44.9568421

115701

44.9568421

ST638

888.5

125469

888.5

**

129332

DAS
86
9-89

DAS
28
9-89

D3296-041B

Manufactured No

D3296-041R

Door Assembly, Blank

DAS
46
9-89

Location

Loc Qty

Loc Code

ST409

44.9568421

115701

44.9568421

ST638

888.5

125469

888.5

**

129333

DAS
86
9-89

DAS
28
9-89

D2463

Manufactured No

D2463

1/2" Seal (\$Per Foot)

DAS
38
9-89

Location

Loc Qty

Loc Code

ST409

44.9568421

115701

44.9568421

ST638

888.5

125469

888.5

**

4.76

DAS
28
9-89

(D2463-0530) CUT (1) AT 53.00" PER KIT

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, February 03, 2015 1:34:48 PM

Work Order ID: 129330

129330

Parent Item: D350-567-115B

D350-567-115B

Parent Item Name: Interior Floor Window, Blank

Start Date: 2/3/2015

Required Date: 2/10/2015

Start Qty: 1.00

Required Qty: 1.00

AN526C632R12

Purchased

No

110

Each

202.0000

9 9

AN526C632R12
Screw

DAS
46
9-89

**

DAS
66
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST328

202

m126474

100

m128403

102

No

110

Each

236.0000

6 6

NAS1149DN632J

Purchased

NAS1149DN632J
Washer

DAS
46
9-89

**

DAS
66
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST270

236

M127255

100

M128812

136

No

110

Each

488.0000

9 9

MS21042L06

Purchased

MS21042L06
Nut

DAS
46
9-89

**

DAS
66
9-89

FEB 05 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

ST304

350

m131294

50

m131317

300

ST305

138

m129499

11

m130325

127

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 129330

129330

Parent Item: D350-567-115B

D350-567-115B

Parent Item Name: Interior Floor Window, Blank

Start Date: 2/3/2015

Required Date: 2/10/2015

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

110

Each

2,498.000

21

2

MS20470AD4-5
RIVET, UNIVERSAL HEAD

DAS

46

9-89

**

DAS

66

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

2248

m128401

2216

m128813

32

ST310

250

m128813

250

MS20470AD4-6

Purchased

No

110

Each

1,139.000

115

115

MS20470AD4-6
RIVET

DAS

46

9-89

**

DAS

66

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

CCK003

1037

m128754

1037

GA

102

127305

102

MS20470AD4-7

Purchased

No

110

Each

1,503.000

15

15

MS20470AD4-7
Rivet, Universal Head

DAS

46

9-89

**

DAS

66

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

LG002

593

m128228

593

ST310

910

123525

910

Tuesday, February 03, 2015 1:34:48 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REFERENCE ONLY

DART AEROSPACE LTD.

FEB 10 2015

DAS
46
9-89

D350-567
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5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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